

734-011

Dart Aerospace Ltd.

Date: Wednesday, 22/04/2009 11:40:21 AM
 User: Julie Dawson

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : GHW ASSEMBLY R22 |
| Job Number : 47367A | |
| Estimate Number : 10789 | |
| P.O. Number : | Part Number : D022734041 |
| This Issue : 22/04/2009 S.O. No. : | Drawing Number : D3380 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 1/1 Type : R & D LG FAB | Drawing Revision : B |
| Previous Run : 47366A | Material : |
| Written By : | Due Date : 15/06/2009 Qty: 1 Um: Each |
| Checked & Approved By : <u>JW 09.04.22</u> | |
| Comment : Est Rev:B 05.08.19 Revised per CHG002 KJ/RF | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Note: If D022-734-041 is a W/O on it's own,

Copy bluefiles and create labels per PPP D022-734-041

CHG002

N/A

2.0

D33571

Wheel Shaft

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3357-1

Wheel Shaft

B25167

pC09.04.29

3.0

D33573

Lock Shaft

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3357-3

Lock Shaft

B25168

pC09.04.29

4.0

D33591

Spacer

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3359-1

Washer

B22552

pC09.04.29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Drawing Name: GHW ASSEMBLY R22

Job Number: 47367A

Part Number: D022734041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D3379041

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3379-041

Arm Weldment

~~B22353~~

B223506

plc09.04.29

6.0

D33801

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3380-1

Handle

~~B23506~~

B22353

plc09.04.29

7.0

D33811

Handle Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3381-1

Label

B29494

plc09.04.29

8.0

D3399041

Wheel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3399-041

Wheel Assembly

B29916

plc09.04.29

9.0

GP1R

Black Vinyl Grip



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 GP-1R

Black Vinyl Grip

M16871

plc09.04.29

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part Number: D022734041

Job Number:



Seq. #: Machine Or Operation: Description :

✓ 10.0 VA1140 Snap Button



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 VA-1140

Snap Button

M16372

Plc09-04-29

✓ 11.0 159016 3/4"-16 UNF Thick Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 159-016

3/4"-16 UNF Thick Nut,Span

M16905

Plc09-04-29

✓ 12.0 178039 1/2"-20UNF Nylon Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 178-039

1/2"-20 UNF Thin Nylon Lock Nut,Span

M16905

Plc09-04-29

13.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per Dwg D3380

A/R

262 Locktite

M110005

Plc09-04-29

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/29 (X)

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Rev A

SS 09/04/29 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number: 47367A

Part Number: D022734041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/30
MF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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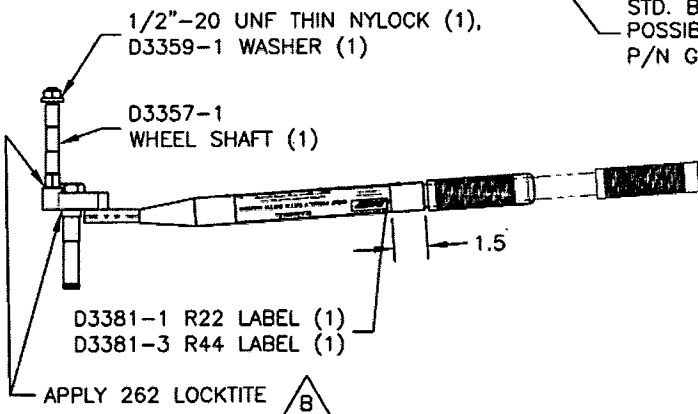
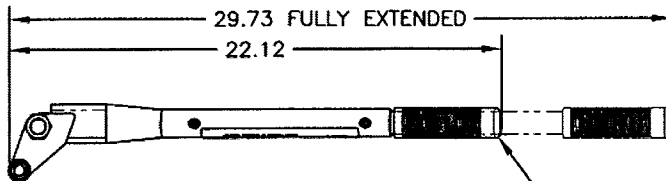
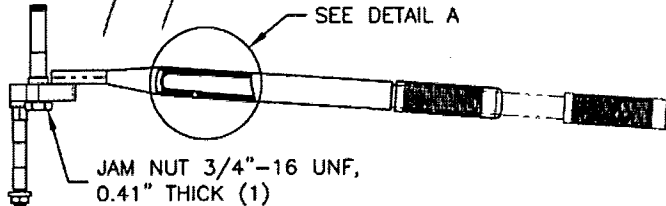
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NOTE: Date & initial all entries

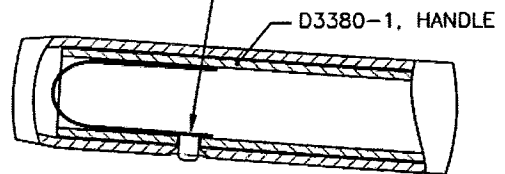
DART

| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3380 | REV. B SHEET 1 OF 2 |
| DATE 05.07.21 | | TITLE GROUND HANDLING ASS'Y | SCALE 1:8 |
| A | 04.12.13 | NEW ISSUE | |
| B | 05.07.21 | ADD LOCKTITE | |

RELEASED
[Signature]
05/08/15



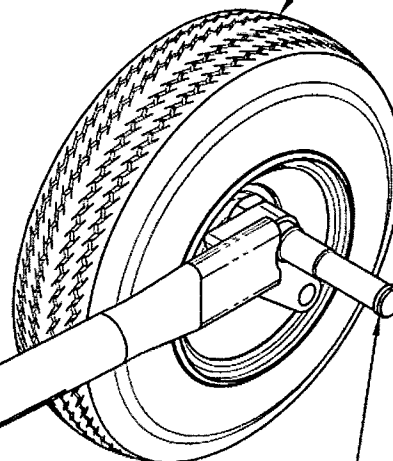
0.300 SNAP BUTTON,
POSSIBLE SUPPLIER:
REID TOOLS SUPPLY CO.,
P/N VA-1140.
INSTALL BUTTON TO
HANDLE D3380-1.



DETAIL A
SCALE 1:2

STD. BLACK VINYL GRIP, 1.000 I.D. x 4.75 LONG
POSSIBLE SUPPLIER, REID TOOLS SUPPLY CO.
P/N GP-1R (1)

D3399-041
WHEEL ASS'Y (1)



D3380-1
HANDLE (1)

D3357-3, R22 LOCK SHAFT (1)
OR
D3357-5, R44 LOCK SHAFT (1)

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 47367A

ISOMETRIC VIEW
SCALE 1:4

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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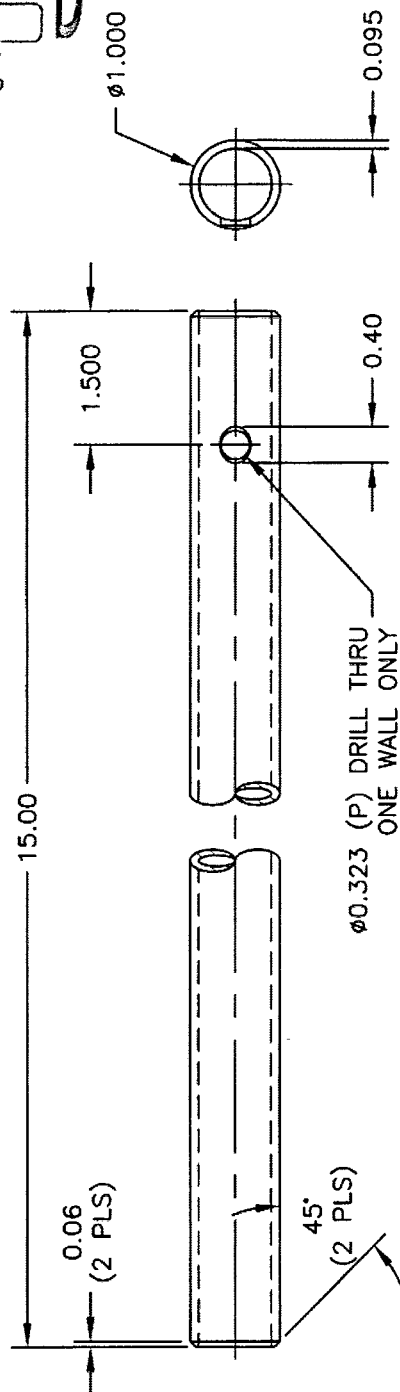
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NOTE: Date & initial all entries



| | | | |
|------------------|----------------|---|------------------------|
| DESIGN 3 | DRAWN BY 7# | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED 6 | APPROVED | DRAWING NO. D3380 | REV. B SHEET 2 OF 2 |
| DATE 05.07.21 | | TITLE GROUND HANDLING ASS'Y | SCALE 1:2 |

RELEASED
05/08/15



D3380-1 HANDLE

NOTES:

- 1) MATERIAL: 1018-1025 ROUND TUBING MILD STEEL SEAMLESS (REF. DART SPEC. M1018TR1.000)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 0005 4.3 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

3408 COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42867A

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